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(12) **INTER PARTES REEXAMINATION CERTIFICATE** (0231st)**United States Patent****Pearson**(10) **Number:** **US 6,767,487 C1**(45) **Certificate Issued:** **Feb. 15, 2011**(54) **PLASTIC EXPULSION PROCESS**(75) **Inventor:** **Terrence C. Pearson, Nantwich (GB)**(73) **Assignee:** **Cinpres Gas Injection Limited,
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B29C 45/17 (2006.01)
B29C 45/76 (2006.01)

(52) **U.S. Cl.** **264/40.4; 264/40.1; 264/572**(58) **Field of Classification Search** **None**
See application file for complete search history.(56) **References Cited****U.S. PATENT DOCUMENTS**

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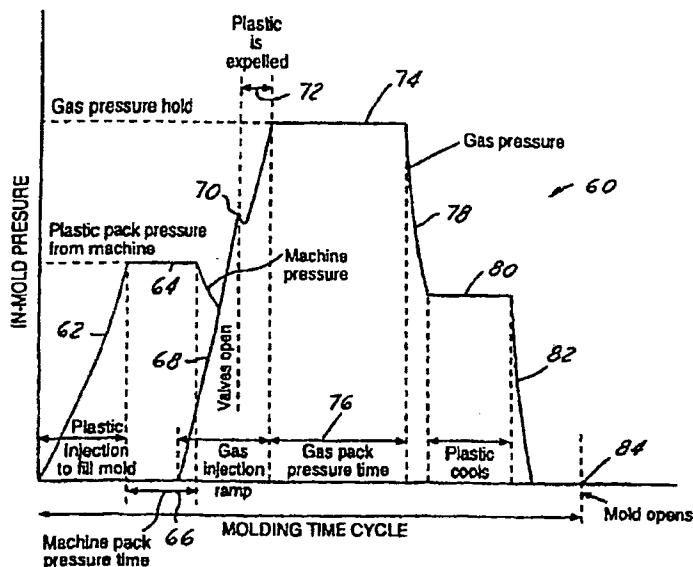
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Primary Examiner—Jerry D. Johnson(57) **ABSTRACT**

A system and process for gas assisted plastic injection molding. The plastic material is injected into the mold cavity and the molding pressure is held for a period of time. Thereafter, gas is injected into the plastic material and the pressure is again held for a period of time. Thereafter, valve members are opened allowing plastic to be expelled into one or more secondary cavities, or to be expelled back into the machine barrel.



1
INTER PARTES
REEXAMINATION CERTIFICATE
ISSUED UNDER 35 U.S.C. 316

THE PATENT IS HEREBY AMENDED AS
INDICATED BELOW.

2
AS A RESULT OF REEXAMINATION, IT HAS BEEN
DETERMINED THAT:

5 Claims 1-16 are cancelled.

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